



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

60602-01

Job Sheet 216139



Part No: 60602-01

Job Qty: 1 pcs

Part Name: Bell 407 Attachment Fittings



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/30/20

Job Tracking No:

Due Date: 12/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 60602 REV.1 IPP REV:A 20.11.27 NEW ISSUE DD VERF:JFS

Ship Via:



Container No: S319840



Part: 60602-01

Job No: 216139

Serial No/Batch: S319840

Revision: REV.1

Inspector:

Exp Date:

Instructions: TC STC SH00-48 Issue 11 dated 19/12/17, F

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Materials

DEC 10 2020

DAS
84
9-89

Job Routing							
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs Run Hrs	Workcenter/Supplier	Sign-off
105	Packaging 1 - Pick Kit	1 pcs	12/17/20	12/17/20	0.00 0.00	Packaging 1 - 1	DAS 84 9-89 DEC 07 2020
110	QC 4	1 pcs	12/17/20	12/17/20	0.00 0.00	QC 4 - 28	
						QC 4 - 58	
						QC 4 - 69	
						QC 4 - 9	DAS 69 9-89
						QC 4 - 46	
						QC 4 - 68	
						QC 4 - 72	
						QC 4 - 74	
						QC 4 - 75	DEC 10 2020
						QC 4 - 78	
						QC 4 - 84	
						QC 4 - 80	
						QC 4 - 85	
120	Packaging 3-1 - Stock - B4B	1 pcs	12/17/20	12/17/20	0.00 0.00	Packaging 3 - 1 - B4B	DEC 10 2020
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS 69 9-89
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 37 - B4B	DAS 21 9-89
130	QC 21 - FG	1 pcs	12/17/20	12/17/20	0.00 0.00	QC 21 - FG - 21	DEC 10 2020
						QC 21 - FG - 70	
						QC 21 - FG - 9	
						QC 21 - FG - 77	
						QC 21 - FG - 28	

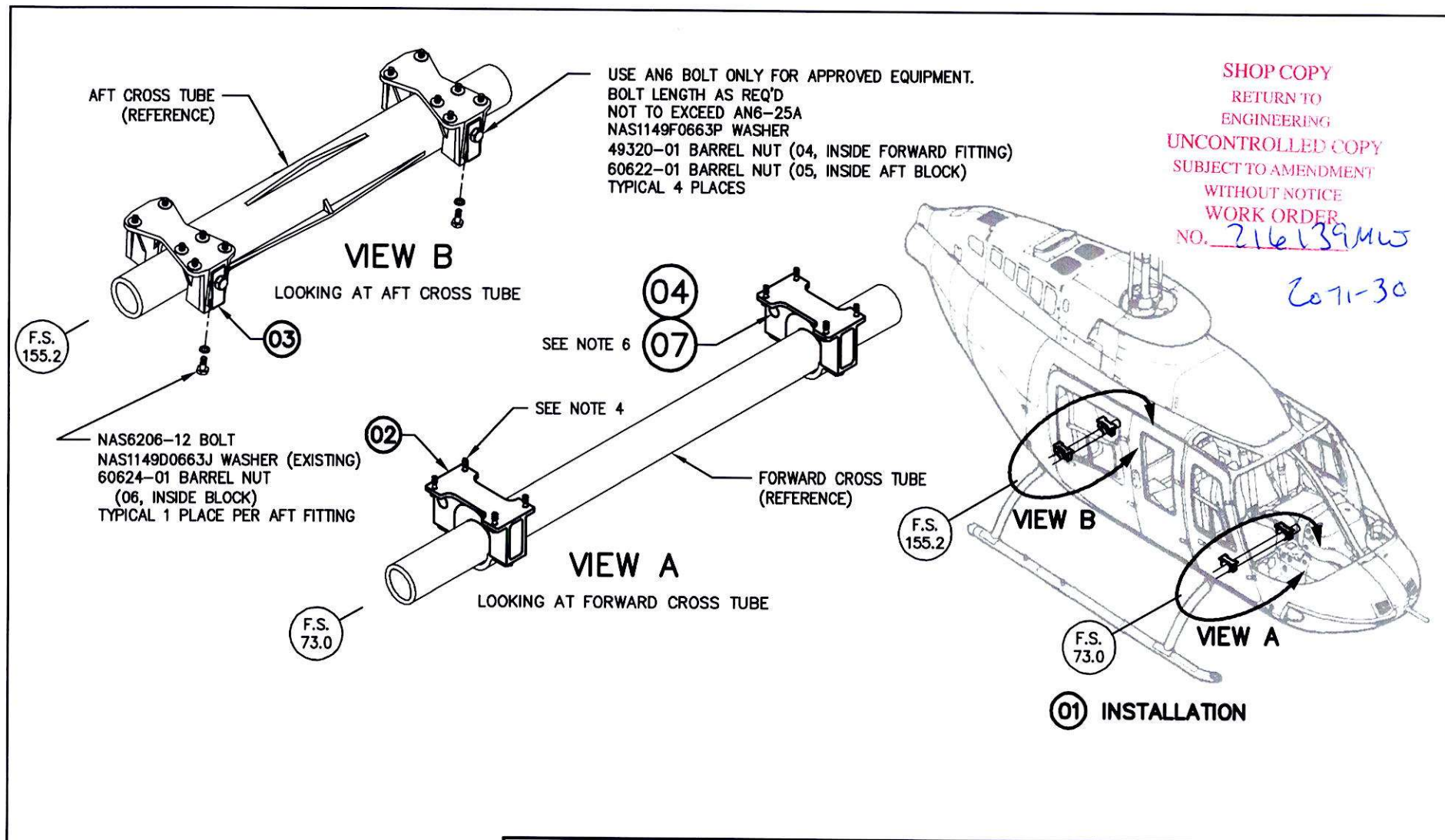
Part Op 120 - Identify as per dwg & Stock Location: _____
 Descriptions: 130 - QC21- Final Inspection - Work Order Release

018417

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
49320-01	Barrel Nut	2 Ea (2 ea)	105-Packaging 1 - Pick Kit	5270619
60620-01	Bell 407 Aft Block	2 Ea (2 ea)	105-Packaging 1 - Pick Kit	5271711
60621-01	Bell 407 Forward Fitting	2 Ea (2 ea)	105-Packaging 1 - Pick Kit	5271711
60622-01	Barrel Nut	2 Ea (2 ea)	105-Packaging 1 - Pick Kit	5269933
60624-01	Barrel Nut - Pat D?	2 pcs (2 ea)	105-Packaging 1 - Pick Kit	5288936
AN6-20A	Bolt	4 Ea (4 ea)	105-Packaging 1 - Pick Kit	5190516
MS16625-4075	Retainer Ring	2 Ea (2 ea)	105-Packaging 1 - Pick Kit	5318642
NAS1149F0663P	Washer (AN960-616)	4 Ea (4 ea)	105-Packaging 1 - Pick Kit	5294596
NAS6206-12	Bolt	2 Ea (2 ea)	105-Packaging 1 - Pick Kit	5314696

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
105-Packaging 1 - Pick Kit	49320-01	2	191	0
	60620-01	2	37	0
	60621-01	2	1	0
	60622-01	2	32	0
	60624-01	2	2	0
	AN6-20A	4	15	0
	MS16625-4075	2	0	0
	NAS1149F0663P	4	242	0
	NAS6206-12	2	0	0
Part Specifications				
Specifications could not be found.				

Plex 11/30/20 11:22 AM Dart.lajeunesse.marie



2	NAS6206-12		BOLT	APPROVALS	DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca				
4	NAS1149F0663P		WASHER	DRAWN: JEFF CLARKE	25 MAR 2004					
4	AN6		3/8" BOLT	CHECKED: E. BURGOIN	25 MAR 2004					
2	MS16625-4075	07	RETAINER RING	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 407 EXTERNAL ATTACHMENT PROVISIONS INSTALLATION				
2	60624-01	06	BARREL NUT							
2	60622-01	05	BARREL NUT							
2	49320-01	04	BARREL NUT							
2	60620-01	03	AFT BLOCK							
2	60621-01	02	FORWARD FITTING							
	60602-01	01	INSTALLATION			NOT TO SCALE DWG. SIZE DWG. NO. REV. A4 60602 1				
01	PART NO.	ITEM	DESCRIPTION							
QTY.	LIST OF MATERIALS									

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		
1	DRAWING REFORMATTED; TITLE BLOCK UPDATED; HARDWARE UPDATED	BJC	23/10/2016
	WEIGHT AND BALANCE UPDATED		

NOTES:

1. ATTACHMENT OF ANY EQUIPMENT TO EXTERNAL ATTACHMENT PROVISIONS REQUIRES TRANSPORT CANADA APPROVAL.
2. RAISE HELICOPTER USING HOIST OR JACK RATED FOR OVER 5000 POUNDS WHEN CHANGING FITTINGS.
3. REMOVE BELL LANDING GEAR FITTINGS AND RETAIN ALL HARDWARE AND PARTS REMOVED.
4. INSTALL EXTERNAL ATTACHMENT PROVISIONS USING EXISTING HARDWARE. REFER TO I.P.C. AND M.M. FOR HARDWARE TO BE INSTALLED ON EACH SPECIFIC MODEL AND SERIAL NUMBER OF HELICOPTER.
5. FORWARD FITTING SHALL BE ORIENTED WITH AN6 BOLT ON AFT SIDE. AFT FITTING'S BOLT FACES FORWARD.
6. SECURE BARREL NUTS IN FORWARD FITTINGS WITH RETAINER RINGS TO PREVENT LOSS WHEN PROVISION IS NOT IN USE.
7. TORQUE AN6 BOLT 90-110 IN-LBS (10.2-12.4 N-m) WHEN IN USE BY EQUIPMENT INSTALLATION.
8. WEIGH FITTINGS REMOVED AND AMEND WEIGHT AND BALANCE DOCUMENTS ACCORDINGLY.

WEIGHT AND BALANCE – STANDARD							WEIGHT AND BALANCE – METRIC						
ITEM	DESCRIPTION	WEIGHT (LB)	LONGITUDINAL ARM (IN)	MOMENT (IN-LBS)	LATERAL ARM (IN)	MOMENT (IN-LBS)	ITEM	DESCRIPTION	WEIGHT (kg)	LONGITUDINAL ARM (mm)	MOMENT (mm-kg)	LATERAL ARM (mm)	MOMENT (mm-kg)
02	FORWARD FITTINGS (TWO)	3.5	73.0	255.5	0	0	02	FORWARD FITTINGS (TWO)	1.6	1854	2944	0	0
03	AFT BLOCKS (TWO)	1.0	152.7	152.7	0	0	03	AFT BLOCKS (TWO)	0.5	3879	1788	0	0
	FORWARD FITTINGS (REMOVED)	-1.4	73.0	-102.2	0	0		FORWARD FITTINGS (REMOVED)	-0.6	1854	-1178	0	0
TOTAL		3.1	98.7	306.0	0	0	TOTAL		1.4	2507	3526	0	0

	APPROVALS	DATE		AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca		
	DRAWN: JEFF CLARKE	25 MAR 2004				
	CHECKED: E. BURGOIN	25 MAR 2004				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 407 EXTERNAL ATTACHMENT PROVISIONS INSTALLATION			
			NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
		SHEET 2 OF 2	A4	60602	1	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					